

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027527**Date Inspected:** 30-Apr-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Pier 7 Job Site**CWI Name:** Steve Jensen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** S.A.S. Components**Summary of Items Observed:**

The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project.

The QAI met with Caltrans Transportation Engineer (CTE) Marcos McManus and the Quality Control Inspector (QCI) Steve Jensen. There were discussions regarding the work related to Contract Change Order (CCO) 179. The QAI was informed that the contractor is installing new, formed stainless steel plate / tracks for the bikepath access gates, the access gates are also being installed. As the gates are being installed, new support arms components are being fit up and welded onto the bikepath hand rails. The QAI was informed that there is a pending Request For Information (RFI) to allow a 6mm fillet weld in-lieu of the detailed 10mm fillet weld. The QAI was informed that there has been verbal approval to proceed with a 6mm fillet weld. The QAI noted that the shielded metal arc welding (SMAW) fillet welding is being performed by Jason Collins, ID 8128. At each access gate location, 2 arms and 2 stoppers are being fit-up and welded. The QAI made random observations of the work in progress and was informed that the welding procedure specification (WPS) being used for this welding is ABF-WPS-D15-F1200A Rev.2. The QAI noted that the welding appeared to be within the requirements of the WPS. As the work progressed, the QAI noted that access gate 17 and 20 have been installed and the work was at access gate 21 was in progress at the end of the shift. See the attached photos.

The QAI reviewed contract documents at pier 7. The QAI used approved weekly welding report submittals and cross referenced the welding and inspection status as reported with QA records to identify the overall weld status. The QAI completed reviewing the informal welding report packages 110, 111 and 112. The QAI noted that several reports reference a welding procedure specification that is not approved by the Engineer. The QAI noted

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that the contractor has submitted a non-conformance report documenting the un-approved WPS and the QAI noted that the WPS is being qualified at this time. The QAI met with the Quality Control Inspector William Norris and reviewed report deficiencies that have been identified. The QAI also relayed the review summary to the QAI Lead Bill Levell.



### Summary of Conversations:

The QAI relayed the status of the CCO 179 access gate tracks and document reviews to the QAI Lead Bill Levell. Except as described above, there were no other notable conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, (510) 385-5910, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Croff, Scott	Quality Assurance Inspector
<b>Reviewed By:</b>	Levell, Bill	QA Reviewer

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